

5/15

<b>DART AEROSPACE LTD</b>	<b>Work Order :</b>	<b>22587</b>
<b>Description: Aft Cap</b>	<b>Part Number:</b>	<b>D2646</b>
<b>Drawing: D2646 Rev. A</b>	<b>Qty:</b>	<b>40 39</b>

Step	Location	Procedure	By	Date	Qty
1	EXPEDITING	Issue Work Order	FF	05.03.02	40
2	PURCHASING	Issue P/O: <u>2057679</u> Spin per Dwg D2646 <b>Material release note required</b>	U	05-03-02	40
3	QC	Inspect Level 6 <b>Ensure material release note is attached</b>	SB	05/04/29	40
4	METAL	Drill as per Dwg D2646 using DT 8026 Open holes to .19/64"	SB	05/05/02	39 (P10)
5	METAL	Deburr	SB	05/05/02	39
6		Acid etch and alodine as per QSI 005 4.1	ML	05 05 11	39
7	QC	Inspect Level 7	2	05 05 13	39
8	FINISHING	Powder Coat White (Ref. 4.3.5.1) as per Dart QSI 005 4.3	FF	05/05/12	
9	QC	Inspect Level 3	MM	05 05 12	
10	STORES	Pick: Qty <u>2</u> Part Number <u>ALS7-1032-130L or</u> <u>ALS7-1032-130 or</u> Description <u>Insert</u> Batch <u>M16197</u> <u>ALS4-1032-130</u>	FF	05/05/16	35
11	METAL	Install Inserts as per Dwg D2646	FF	05/05/16	39
12	QC	Inspect Level 7	2	05-05-16	39
13	STORES	Identify and Stock	MM	05 05 16	39
14 a	EXPEDITING	Close W/O <u>7.29</u> Cost / Part <u>2.77</u>	AP	05/05/17	39

Rev	Date	Change	Revised By	Approved
C	98.01.16	Changed Inspection Levels	BW	
D	99.01.04	Added Powder Coat	DM	
E	00.06.22	Removed P/O for powder coat	EC	

26	RG	Receive + Inspect for transit damage	CL	05/04/01	870
146	DL	Close w/o Inspect level 21	FF	05.05.24	39

**RELEASED**  
JUN 26 2000

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector
05-04-01	26	permanent change		05-04-25	N/A	W	 05-05-24

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
05/05/02	4	hole over tolerance	 05/05/02	Scrap	SB 05/05/02	 05-05-02	 05-05-02	 05-05-02

Part No: D2646 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: Date: 05/05/26

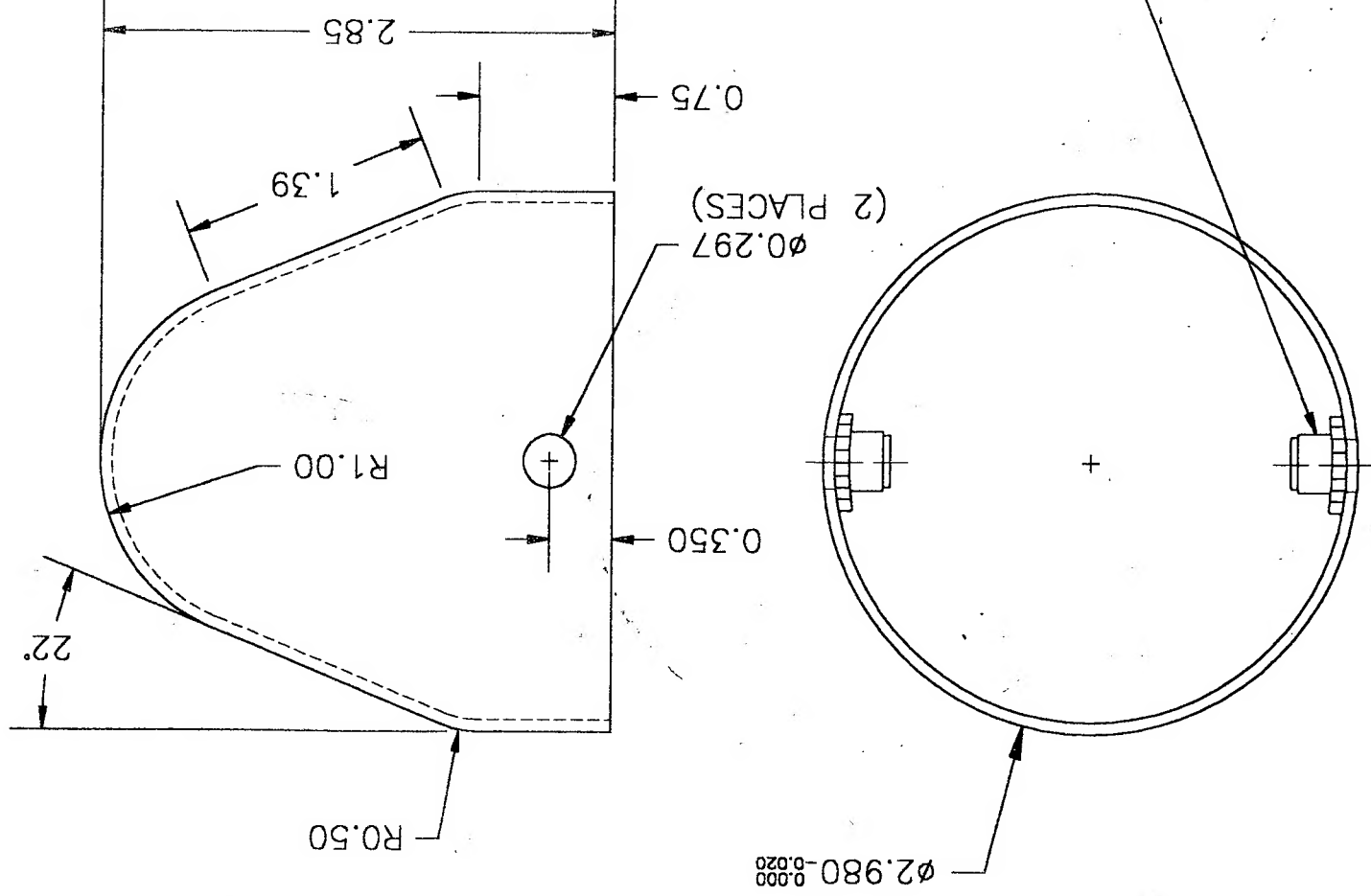
NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2646
DATE 97:03:25	TITLE CAP	REV. A SHEET 1 OF 1
97:03:25		SCALE 1:1

RELEASED  
R 47/04/25 DS



INSTALL ALS4-1032-130 (OR AKS7-1032-130)  
INSERT ON INSIDE OF CAP AFTER ALODINING (2 PLACES)

MATERIAL: 1100-0 0.063 THICK (88-A-250/1)  
FINISH: ACID ETCH, ALODINE PER PART QST 005 4.1  
TOLERANCES ARE PER PART QST 018 UNLESS OTHERWISE NOTED

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SHEET DOCUMENT  
FOR NOTICE

WORK ORDER

NO. 22587

## Job Costing Report

Dart Aerospace Ltd.  
Hawkesbury

Mar 01, 2005  
11:19 am

Work Order No : 0022587  
Project Name : D2646  
Project For : WK515  
Work Order Type : Main  
Main WO Number :  
House Part Number : D2646  
Description : Aft Cap  
Manufactured : Yes  
Amount Req'd : 40  
Amount Done : 0  
Start Date : 03-01-05  
Est Finish Date : 03-30-05  
Act Finish Date :  
Drawings Req'd : No  
Ok for Approval :  
Approval Rec'd :

Department Code:  
Burden Flags : NNNNNNNN  
WO Status : Open  
Invoice State : Not Invoiced  
Invoice Date :  
Invoice Number :  
Invoice Amount : 0.00  
  
Order Entry No :  
OE Value : 0.00  
  
Est Margin : 0.000%  
Actual Margin : 0.000%  
  
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00



Sieg's Manufacturing Ltd.

604 530-7455 fax 604 530-7490  
6236-205 Street, Langley, British Columbia, Canada. V2Y 1N7

## INSPECTION REPORT

DATE: MAR 22 05

CUSTOMER: Dart

INVOICE #: 28717 SUPPLIER #: P62007679

DESCRIPTION OF INSPECTION: SPINNING PARTS

PART #	QTY.	MATERIAL	CHECK HOLES	DEBUR EDGES	INSP BY.
D2000-109	10	1100064	✓	✓	rlc
D2000-111	10	1100064	✓	✓	rlc
D26116 R.A.	40	1100064	✓	✓	rlc

NOTES OF INSPECTION:

NOTES OF REJECT:



1480 Manheim Pike  
Lancaster Pa 17601

# CERTIFICATION OF TEST RESULTS

<b>SOLD TO</b>	COPPER & BRASS SALES INC 22355 WEST ELEVEN MILE ROAD SOUTHFIELD, MI 48034	<b>SHIP TO</b>	COPPER & BRASS SALES INC 6555 E. DAVIDSON DETROIT, MI 48212	<b>CERT NO</b> 0000598687
	<b>DATE</b> 10/26/2004			
				<b>SKID NO</b> 322296
				<b>SKID WGT</b> 9,760
				<b>PAGE</b> 1 OF 1

<b>ORDER NO</b>	LB4176	<b>PO NO</b>	C99792			<b>MILL FINISH</b> NOT ANODIZE QUALITY OUT: STANDARD MILL FINISH IN: STANDARD MILL FINISH NOT EMBOSSED
<b>ITEM NO</b>	1	<b>PART NO</b>	050393-8			
<b>ALLOY</b>	1100	<b>TEMPER</b>	O	<b>FORM</b>	COIL	
<b>GAUGE</b>	.06300	<b>WIDTH</b>	48.0000	<b>LENGTH</b>	0.0000	

LOT: 238066 COIL: B01 DROP: 440525

INGOT	SI	FE	CU	MN	MG	CR	NI	ZN	TI
4405252	0.11	0.42	0.08	0.02	0.002	0.001	0.004	0.003	0.02

HEAD ULTIMATE STRENGTH 12.2 KSI  
TAIL ULTIMATE STRENGTH 12.6 KSI  
HEAD YIELD STRENGTH (OFFSET = .2%) 4.9 KSI  
TAIL YIELD STRENGTH (OFFSET = .2%) 5.6 KSI  
HEAD ELONGATION (G.L. = 2 IN) 35.5 %  
TAIL ELONGATION (G.L. = 2 IN) 33.5 %

CHEMICAL COMPOSITION ACCORDING TO ASTM E-1251-04  
MECHANICAL PROPERTIES ACCORDING TO ASTM B-557-02a

MECHANICAL AND CHEMICAL PROPERTIES MEET THE REQUIREMENTS OF:  
ASME SB209 1100 O, AMS 4001H 1100 O,  
ASTM B209-04 1100 O, AMS-QQ-A-250/1 1100 O

CERTIFICATION OF TEST RESULTS SHALL NOT BE REPRODUCED EXCEPT IN FULL  
\*\* END OF CERTIFICATION \*\*

*Handwritten:*  
Henry C. S. 10/28  
C/O  
Sorel  
LTS

This document certifies the material above has been tested in accordance with applicable specifications described herein and has met those requirements. The material is subject to terms and conditions on the Alcoa sales order agreement.

Authorized By: JEFF HREADY, LAB SUPERVISOR

